

Date: Friday, 5/25/2007 8:26:23 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 412 WEB |
| Job Number | : 32629 | | |
| Estimate Number | : 10466 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D33891 |
| This Issue | : 5/25/2007 | S.O. No. | : <i>N/A</i> |
| Prsht Rev. | : NC | Drawing Number | : D3389 REV C |
| First Issue | : <i>N/A</i> | Project Number | : N/A |
| Previous Run | : 32291 | Drawing Revision | : C |
| | | Material | : <i>N/A</i> |
| | | Due Date | : 6/10/2007 |
| Written By | : <i>[Signature]</i> | Qty: | 4 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> 07.05.28 | | |
| Comment | : Est Rev:A 05.08.31 New issue KJ/JLM | | |
| | : Est Rev:B 06-02-08 As per Rev C JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|-----------|-----------------------|
| 1.0 | D25003100 | Ext'n -1' Beam Web 4" |
|-----|-----------|-----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Ext'n -1' Beam Web 4"

Pick:

| | | | |
|-----|-------------|---------------|----------------|
| Qty | Part Number | Description | Batch |
| 1 | D2500-3-100 | Web Extrusion | <i>B 25751</i> |

JD 7-6-6

| | | |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1
 1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

JD 7-6-6

| | | |
|-----|-----|-------------------|
| 3.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

DP 7-6-6

| | | |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

JD 7-6-7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 07/06/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 32629

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



pm-07-06-18 (4)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

JD 7-6-7

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

7/25/06/19

Job Completion



W 8-06-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

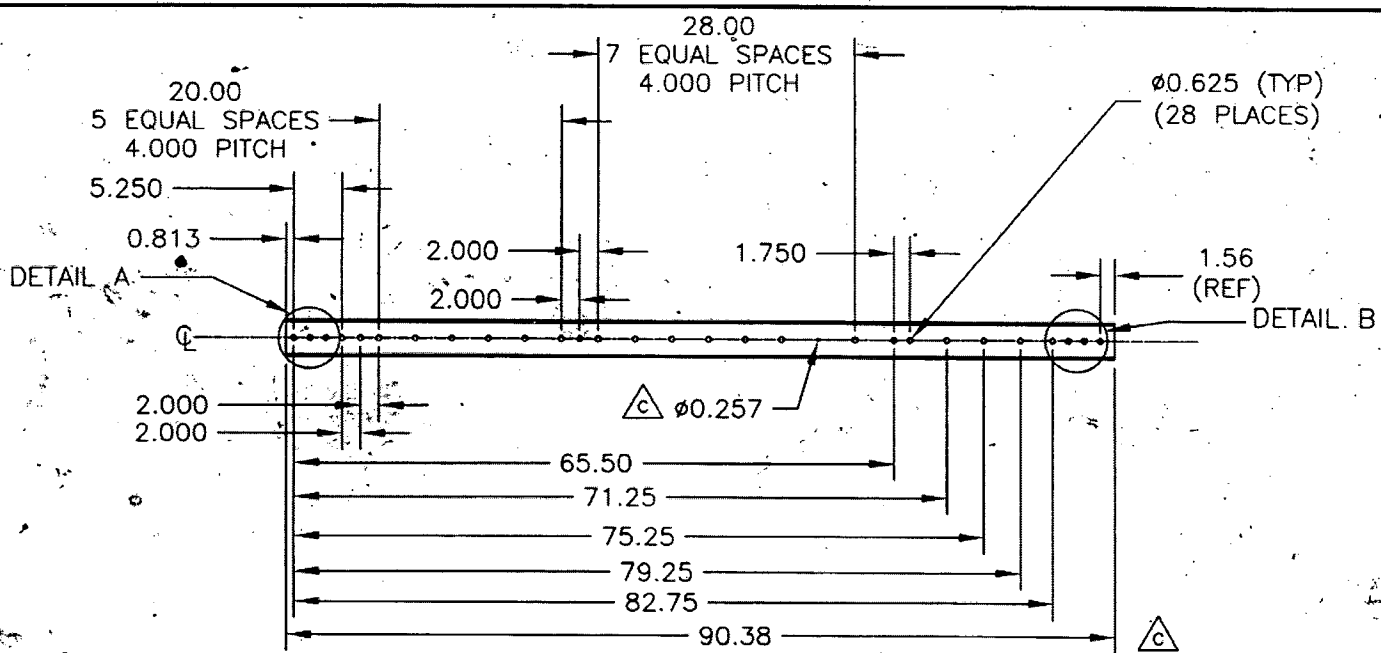
NOTE: Date & initial all entries

DART

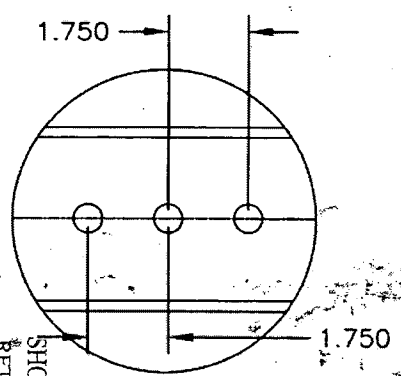
RELEASE

06.01.23

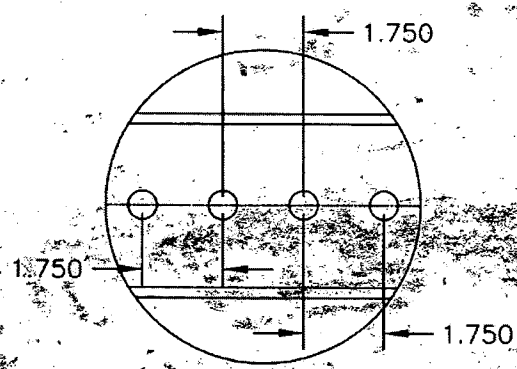
| | | | | | | |
|---------|----------|--------------------------------------|---------|--------------------------|------------------|--------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE USA, INC. | PORT HADLOCK, WA | REV. C |
| CHECKED | PH | APPROVED | PH | DRAWING NO. | 03389 | SHEET 1 OF 1 |
| DATE | 06.01.23 | TITLE | 412 WEB | SCALE | 1:20 | |
| A | 05.02.07 | NEW ISSUE | | | | |
| B | 05.06.13 | UPDATE DIMENSIONING | | | | |
| C | 06.01.23 | DECREASE OVERALL LENGTH, MODIFY HOLE | | | | |



D3389-1 DRILLING DETAIL



**DETAIL A
(SCALE 1:4)**



**DETAIL B
(SCALE 1:4)**

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32629

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED